

Date: Thursday, 06/09/2007 2:35:21 PM  
User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : AS350-9267 REV.2
Job Number : 34448	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : AS3509267
This Issue : 06/09/2007 S.O. No. :	Drawing Number : AS350-9267
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>1/1</i> Type : SMALL/MED FAB	Drawing Revision : <i>N/A</i>
Previous Run : 32248	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 18/09/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>2</i> Um: <i>3</i> Each
Comment :	<i>12</i>

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	AS3509268	Half Bracket
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Comment: Qty.: 0.5000 Each(s)/Unit Total: 1.5000 Each(s)  
TUBE

*M17679**u 3709-06*

2.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
Powder coat white as per QSI005

*m 105068**OK 07-09-06**(4)*

3.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml 07/09/11 x4 parts*

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

-Install rubber as per Drwg AS350-9228 (See Linda or Peter) — *D3195 rubber 320359*  
-assemble as per drwg AS350-9267 *Contact Ciment M102565*

*ml 07/09/11 (x2)*

5.0	AN417A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total: *8* 12.0000 Each(s)  
Bolt

*2x M101124\*  
6x M102280 v**ml*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 07/08/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AS350-9267 REV.2

Job Number: 34448

Part Number: AS3509267

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: <sup>16</sup>24.0000 Each(s)  
Washer

M5519

✓ml

7.0

MS20365428

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: <sup>8</sup>12.0000 Each(s)  
NUT

M17975 \*~~x4~~

ml 07/09/11

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/11

(X24 assembly)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify & Stk

1/8/11

(2x)

SP

Job Completion



QC21 FINAL W/O release

AP (2)

U 07-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

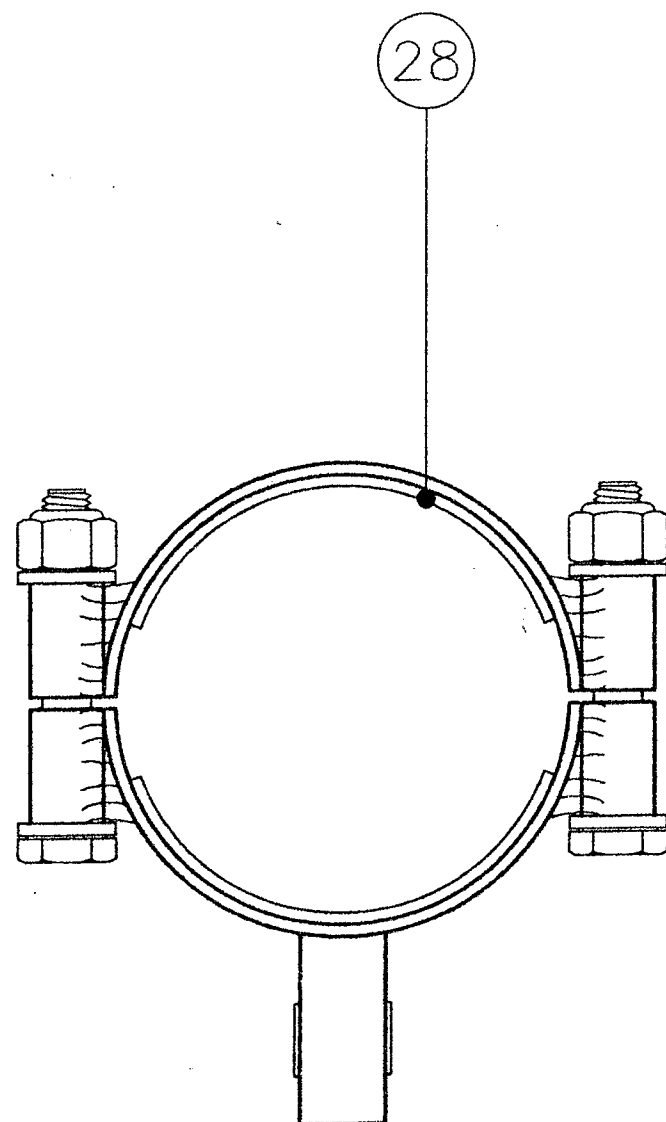
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

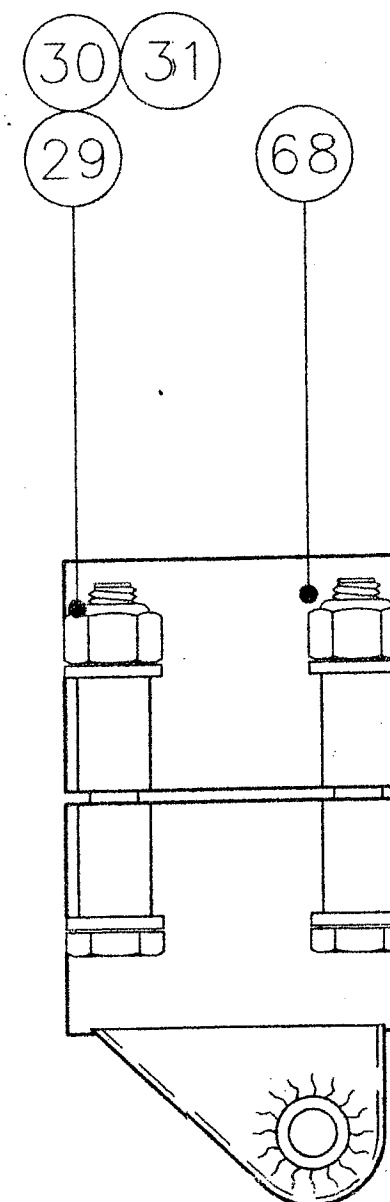
# NOTICE

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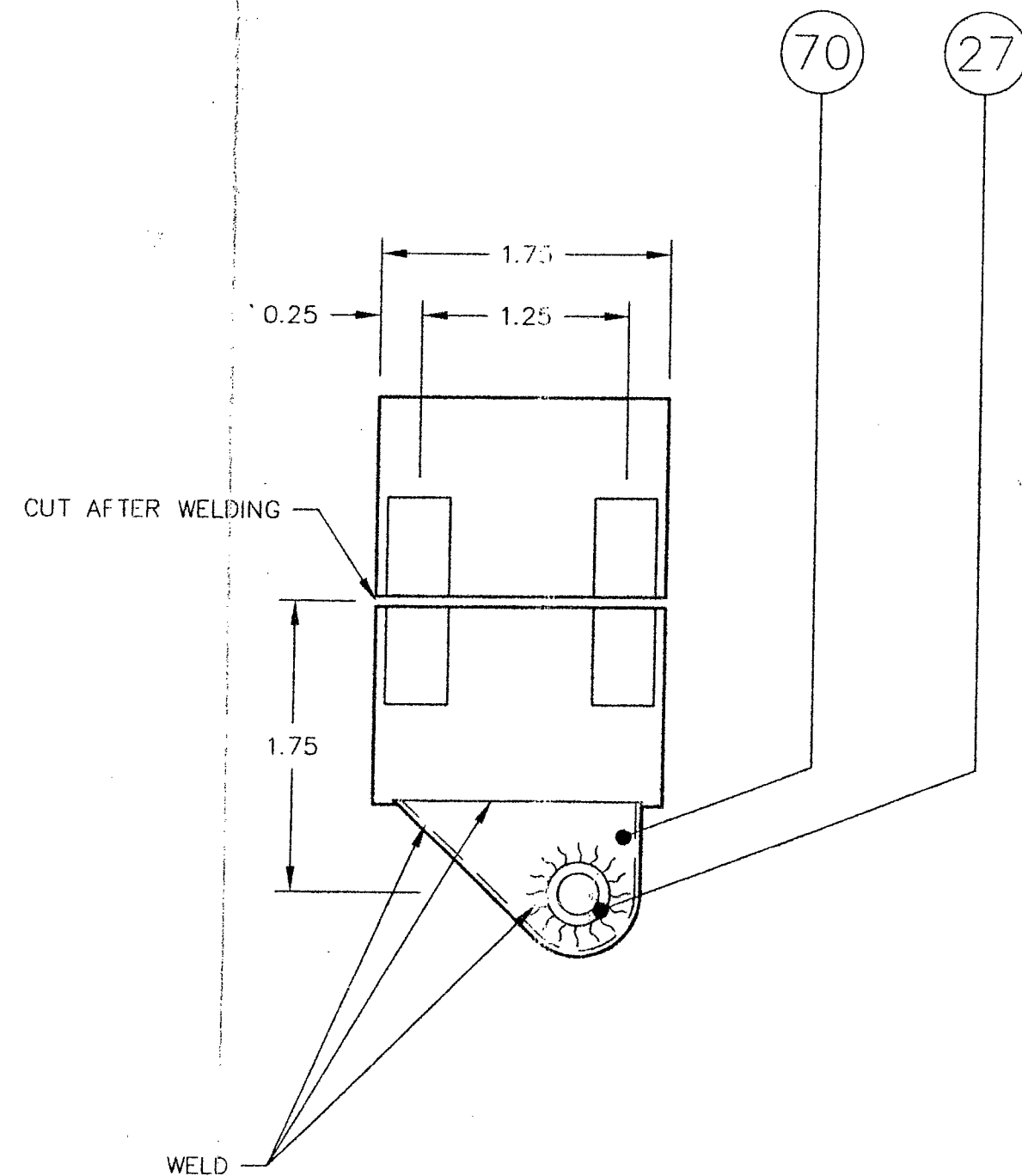
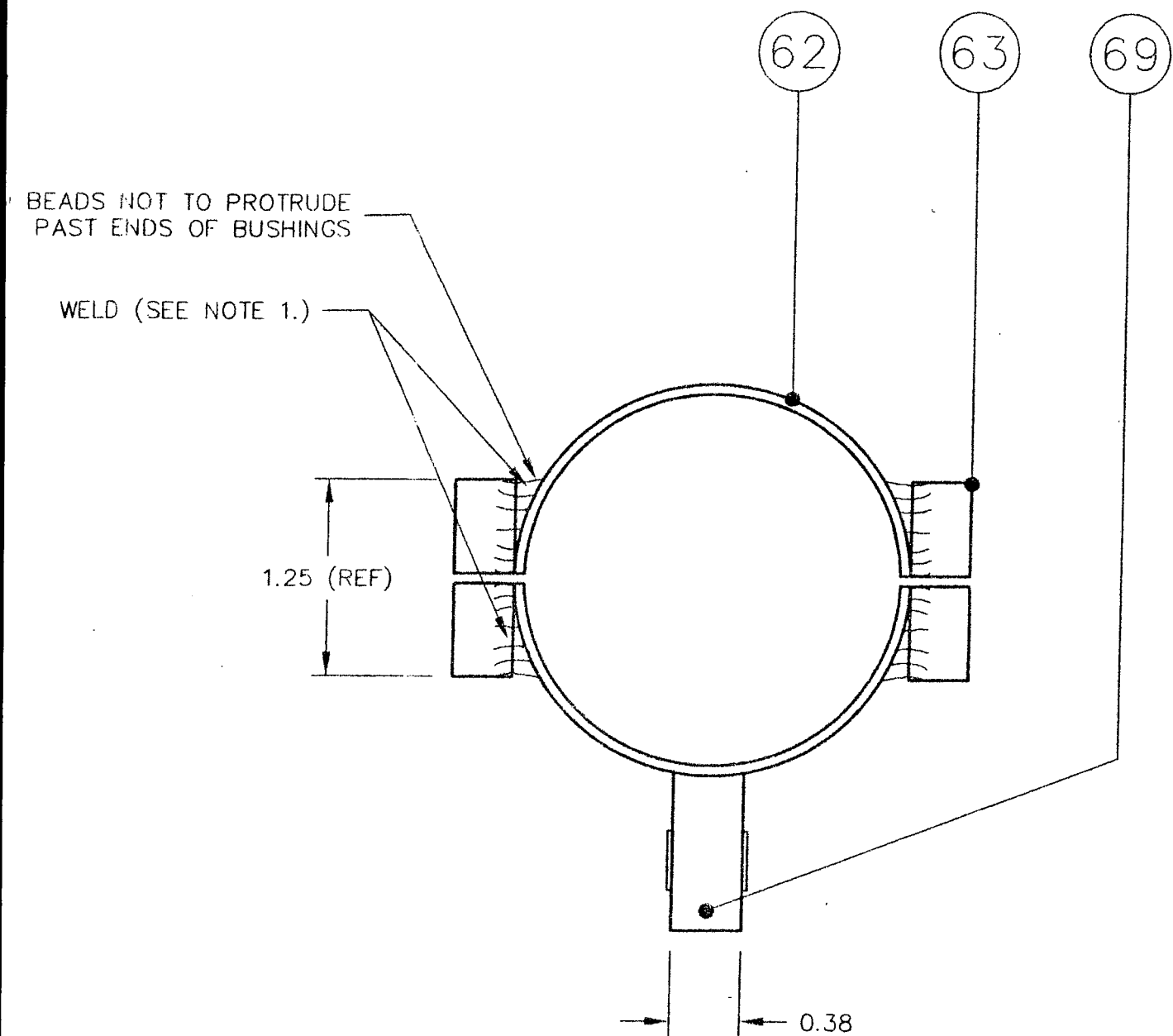
*D3/95  
err fact  
diameter 1/8"*



WELD BEADS  
PAST E

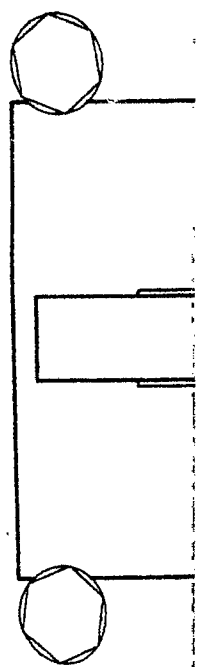
WELD

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUG, ITEM 70, MODIFIED. THICKNESS OF BRKT CHANGED TO 0.38".	E. B.	27 DEC 92
2	NOTE RE. WELD BEADS ADDED TO ITEM 68	D. W.	6 OCT 00

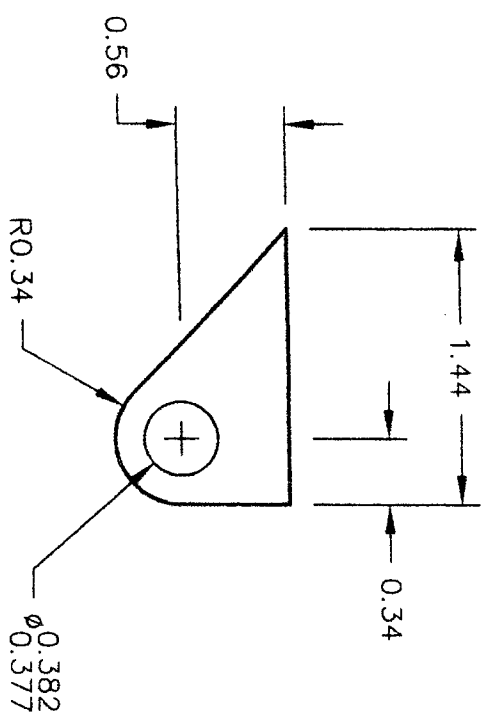


(68) BRACKET

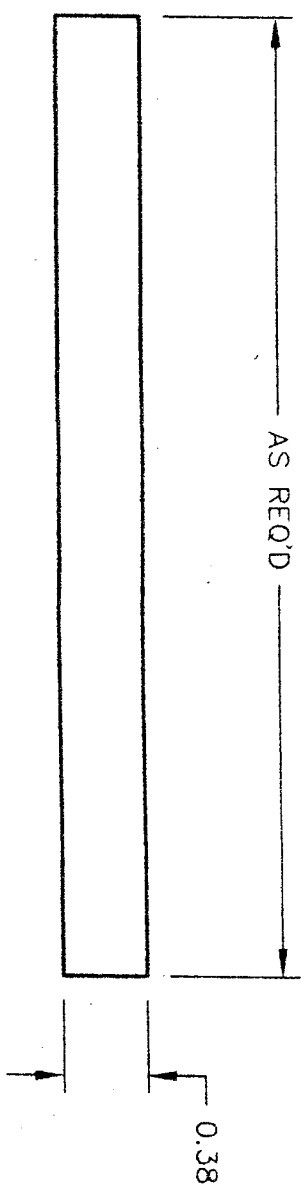
AS350-9267



67 ATTACHMENT BRACKET ASSEMBLY



70 LUG



69 STRIP

# NOTES

1. TIG WELD AS PER MIL-E-23765/1B, CLASS MIL-E-705-2.  
USE FILLER ROD MIL-R-5632, CLASS 2, TYPE 1 (AMS 6457A)
2. FILLET EDGE OF CLAMP ALONG 2.38 I.D. SECTION TO 1/32" RADIUS  
TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE.  
FILLET BOTH TOP AND BOTTOM EDGES.
3. THOROUGHLY CLEAN AND DEGREASE ITEM 68. PRIME  
AND PAINT TO AS PER EXISTING AIRCRAFT COLOR REQUIREMENTS.

	4	AN4-17A	31	BOLT			
	8	AN960-416	30	WASHER			
	4	MS20365-428	29	NUT			
	2	AS350-92-28	28	RUBBER PAD SEE DWG. AS350-9228			
1		AS350-92-27	27	BUSHING SEE DWG. AS350-9227			
2			70	LUG	4130 COND. N SHEET	MIL-S-18729	0.063 THK.
1			69	STRIP	4130 COND. N SHEET	MIL-S-18729	0.036 THK.
4		AS350-92-63	63	BUSHING SEE DWG. AS350-9263			
1		AS350-92-62	62	TUBE SEE DWG. AS350-9262			
	1		68	BRACKET			
		AS350-92-67	67	ATTACHMENT BRKT ASSEMBLY			
68	67	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
QTY.	LIST OF MATERIALS						

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

## APPROVALS

## DATE

DRAWN: E. BURGOIN

15 DEC 92

CHECKED:

STRESS:

FLIGHT TEST:

**AERO DESIGN LTD.**

1055 McTAVISH ROAD N.E.  
CALGARY, ALBERTA T2E 7G9

**EAGLE COPTERS LTD.**

823 McTAVISH RD. N. E.  
CALGARY, ALBERTA T2E 7G9

**AS350 & AS355 CARGO BASKET  
ATTACHMENT BRKT ASSEMBLY**

SCALE 1 : 1

SHEET 1 OF 1

SIZE

DWG. NO.

REV.

**D**

**AS350-9267**

**2**